

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020066**Date Inspected:** 08-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie, Lu Li Qing.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, Traveler rail.

During Random Visual in process Inspection, this QA inspector observed Heat straightening of traveler rails identified as 11TR1-011, 10TR3-037. The attached photographs provide additional detail.

Assembly, Bay 14, 12AE, PP111.5.

During Random Visual in process Inspection, this QA inspector observed fit-up of Floor beam identified as FB3009-001. The attached photographs provide additional detail.

Assembly, Bay 14, 11DE, Deck plate to Edge plate.

FCAW welding of weld joint SEG072\*-045, 046, 047; located on assembly, Bay 14, 11DE. Welder is identified as 044772, 200113, 049339; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

Assembly, Bay 14, 11DE, SEG072.

SMAW welding of weld joint SSD17-PP105-004; located on assembly, Bay 14, 11DE. Welder is identified as

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049861; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2213-B-U2-FCM-1.

Assembly, Bay 14, 12BE, Deck plate to Deck plate.

FCAW welding of weld joint SEG3002\*-009(DP3020A TO DP3021A); located on assembly, Bay 14, 12BE. Welder is identified as 044795; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Assembly, Bay 14, 12CW, PP115.2.

During Random Visual in process Inspection, this QA inspector observed fit-up of Floor beam identified as FB3089. The attached photographs provide additional detail.

Assembly, Bay 14, 12AE.

During Random Visual in process Inspection, this QA inspector observed fit-up of Corner assembly diaphragm identified as CA3001. The attached photographs provide additional detail.

Training for Phased Array Ultrasonic Testing.

This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

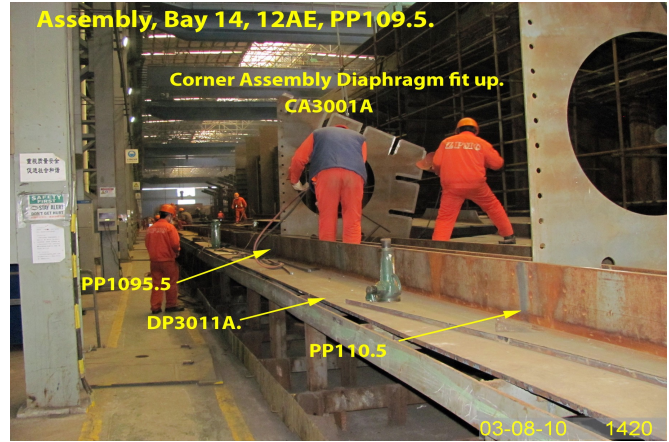


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## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Juvekar,Amit

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer